

Work Order ID 70297

Thursday, June 02, 2011 1:46:03 PM



Page 1

Item ID: D3204-041

Accept



Setup



Start



Revision ID:

Item Name: Release Pedal Assembly

Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3204	Rev A1

100



Large Fab

0.00

Large Fab

Memo

0.00

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" cbore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured. 11dent

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

120



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

5/10/11



xc

EL 117-11 X8

6 8 8/11/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

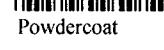
Hand Finishing

6 φ BL 11-7-11

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

M 115128

Memo

0.00

7*Cover holes for bushing***
 START TIME: 7:30 ⁰¹⁼
 OVEN TEMPERATURE: 320 ⁰¹⁼
 FINISH TIME: 8:00

6x φ m-11/07/12

150

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

6 φ BL 11-7-12

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Item ID: D3204-041

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Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Install D3204-7 bushing as shown in Dwg D3204

JP 11/07/12 (6)

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

JP 11/07/12 (6)

180



Identify as per dwg & Stock Location: 6A 0.00

Packaging

Packaging

Memo

*W/O = 70289 (3x) 0.00
W/O = 70604 (3x)*

JP 11/07/13 (6)

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Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

190

QC21- Final Inspection - Work Order Release



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

0.00

11/7/13
ME

11-07-13

Picklist Print

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Page 1

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Work Order ID: 70297



Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C.05.08.11| Added Step 25 | KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 		Manufactured	No			100	Each	12.0000	1	4			

Tube

Location	Loc Qty	Loc Code
WA 68571	10	
WA019	2	
60883	2	

EL 11-7-7.

D3204-11 		Manufactured	No			100	Each	36.0000	1	4			
--------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Plate

Location	Loc Qty	Loc Code
ST45	14	
57522	14	
WA019 55463	22	
	22	

EL 11-7-7

D3204-13 		Manufactured	No			160	Each	12.0000	2	8			
--------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Gusset

Location	Loc Qty	Loc Code
WA019 58211	12	
	12	

EL 11-7-7

12

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 70297



Parent Item: D3204-041



Parent Item Name: Release Pedal Assembly

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-3



Manufactured

No

100

Each

7.0000

1

4



R 11-7-7

Arm

65139X5

Location

WA019

Loc Qty

7

Loc Code

57737

D3204-5



Manufactured

No

100

Each

6.0000



1

4

R 11-7-7

Arm

D3204-7



Manufactured

No

Location

WA

Loc Qty

6

Loc Code

65140

Bushing

D3204-9



Manufactured

No

100

Each

14.0000



1

4

R 11-7-7

Pedal

Location

WA

Loc Qty

14

Loc Code

65141
68573

4

10

4
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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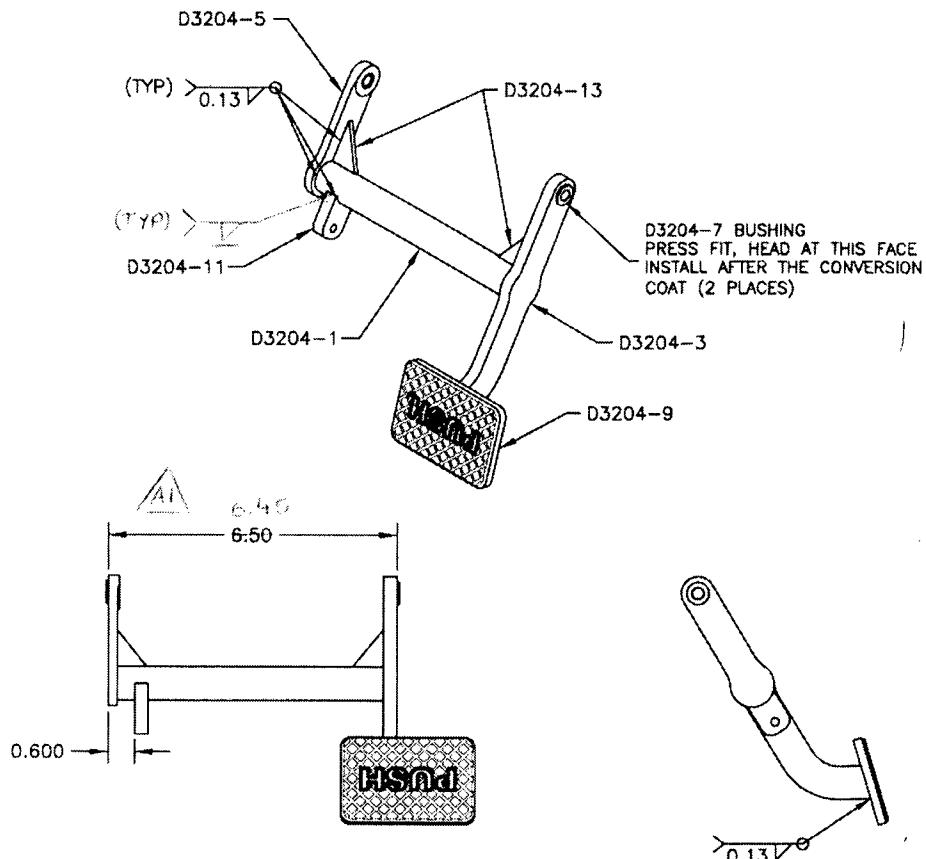
NOTE: Date & initial all entries



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CHECKED	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	

RELEASER
04.01.27

AI 04.01.27 05.07.15 6.45 was 6.30



D3204-041 RELEASE PEDAL ASSEMBLY

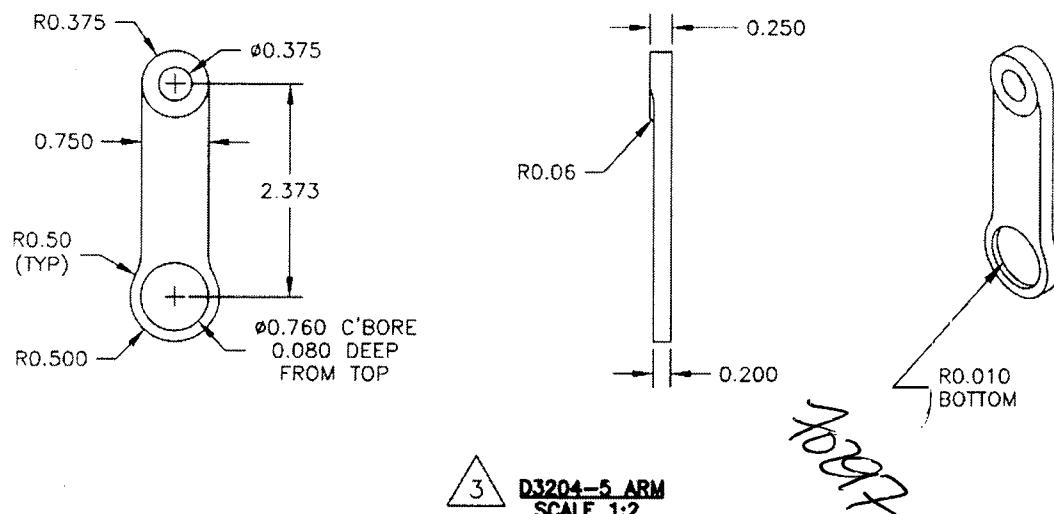
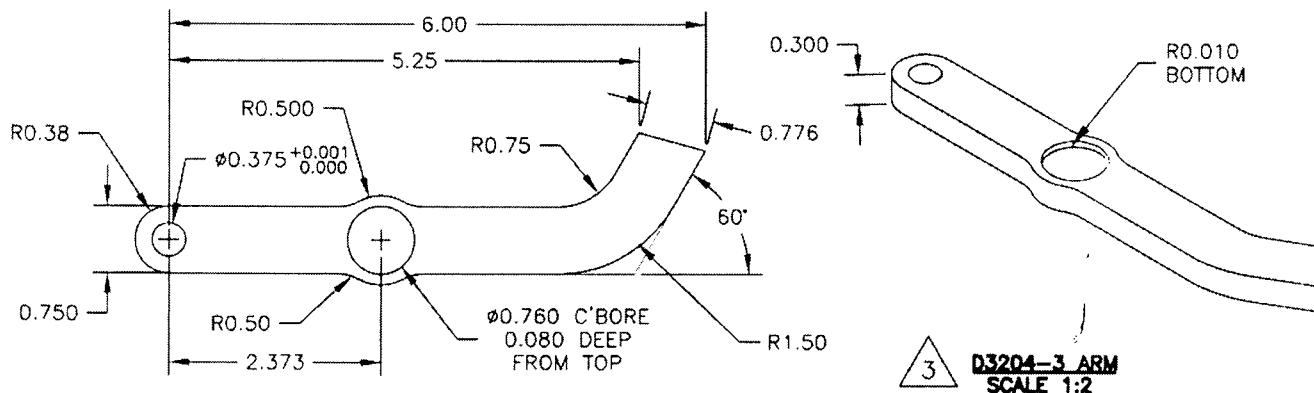
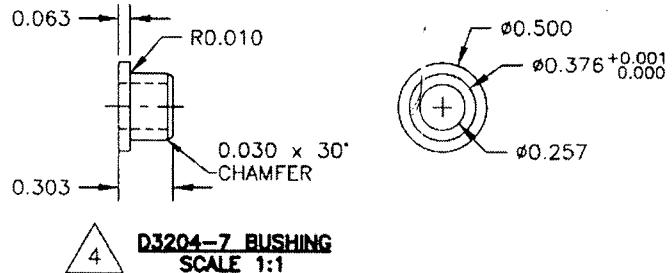
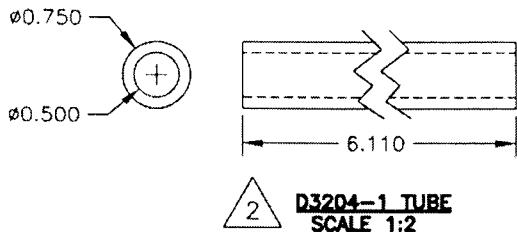
NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T60.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES



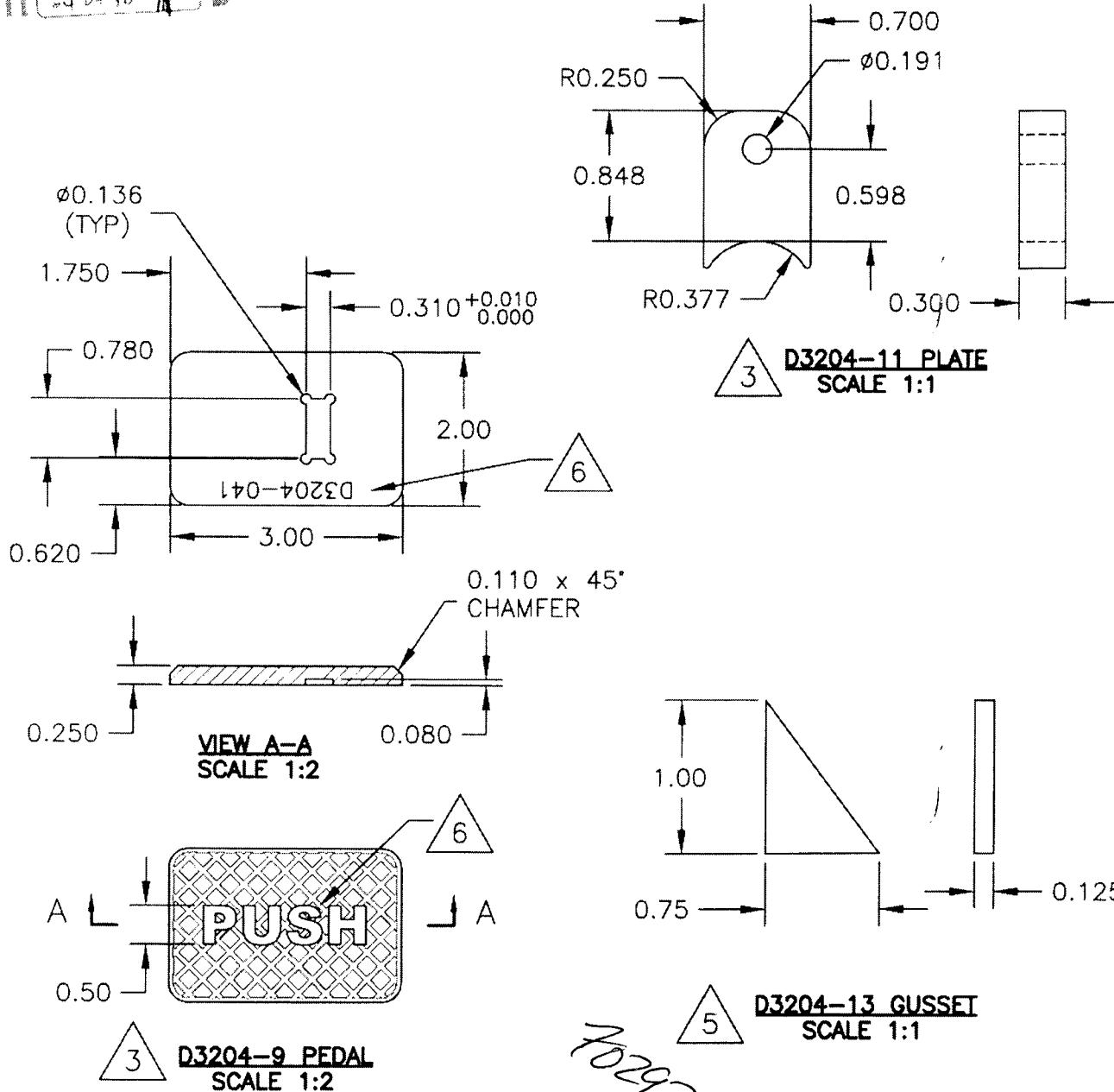
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CHECKED RT	APPROVED RT	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05



DARTCOPY 13
12/04/04

DESIGN 14	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3204
DATE 04.01.27		REV. A SHEET 3 OF 3 TITLE RELEASE PEDAL ASSEMBLY SCALE NTS

RELEASED
04.04.04 H

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